

Work Order ID 86346

June-27-12 3:20:29 PM

86346

Page 1

Item ID: D412-711-101

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Bubble Window

Start Date: 27/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *MLT*

Date: *12/06/28* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D412-711-101	A

100 0.00

100

DC

Document Control

Memo

Photocopy bluefiles and create labels
for PPP D412-711-101 Change 002

0.00

Scrub-Hoc

110 0.00

110

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Set up Machine as per folio FTA 077 and D711W program using mould DT9640

0.00

x5

DL

12/07/03

120 0.00

120

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Cut Blanks to 37.5" by 43"

0.00

x5

DL

12/07/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA
077 Dwg. Rev. A Folio Rev

077

Dwg. Rev.

Folio Rev

A

0.00

140

140

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1) Check Surface finish for undesired marks, voids, dimples etc. 2) Check depth of bubble to ensure conformity to drawing tolerances.

0.00

150

150

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

W/O: 616346		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 442-711-101 PAR #: _____ Fault Category: thermoforming NCR: (Yes) No DQA: 462 Date: 12/07/10
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: ck Date: 12/7/12

NCR: 12-1572		WORK ORDER NON-CONFORMANCE (NCR) # 462.49						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/07/03	130	DID NOT FORM PROPERLY ON FLANGE AREA R.C. clamp set up was incorrect. operate error	S 057042 12/07/04	ADJUST CLAMPS & Reform SCRAP 1 PART	Wh 12/07/03	S 12/07/04	S 057042 12/07/04	S 12/07/04
				M 119347 QTY 1 seen	07/10/12			

NOTE: Date & initial all entries

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Required Date: 11/07/2012 Req'd Qty: 4.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	HAND FINISHING THERMOFORMING								
HandThermo	Memo	0.00				X 4/			12/07/04
Hand Finishing Thermoforming	1) Trim off excess flange material 2) Buff out any light scratches or 3) Etch part number and batch number								
170		0.00							
170	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							12/07/04
Quality Control	1) Visually inspect for clarity, and proper formation.								
180		0.00							
180	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00				(24)			12/07/04
Quality Control	1) Visually inspect for clarity, and proper formation.								

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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185

QC4- 100% Inspect kits for completeness

0.00

185

QC

Memo

0.00

Sizelings

Quality Control

190

Identify as per dwg & Stock Location: _____

0.00

190

Packaging

Memo

0.00

Packaging

12/7/12 (4)

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

CK 12/7/12

12-07-12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	86346
Description: Replacement Window		Part Number:	D412-711-101
Inspection Dwg: D412-711-101 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	<u>Dh</u>	Date:	<u>12/07/03</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	<u>2.04"</u>	✓		<u>Visual DL-02</u>	
1.73	+/-0.030	<u>1.75"</u>	✓		<u>Visual DL-02</u>	
1.98	+/-0.030	<u>1.99"</u>	✓		<u>Visual DL-02</u>	
1.50	Min	<u>1.57"</u>	✓		<u>Visual DL-02</u>	
0.090	Min	<u>0.101"</u>	✓		<u>ULTRA</u>	
0.070	Min	<u>0.92</u>	✓		<u>ULTRA</u>	
0.050	Min	<u>0.76"</u>	✓		<u>ULTRA</u>	
15.0	+/-0.5	<u>15.125"</u>	✓		<u>TAPE QL-01</u>	

Measured by:	<u>Dh</u>	Date:	<u>12/07/04</u>
Audited by:	<u>S</u>	Date:	<u>12/07/04</u>
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ	<u>[Signature]</u>

Dart Aerospace Ltd

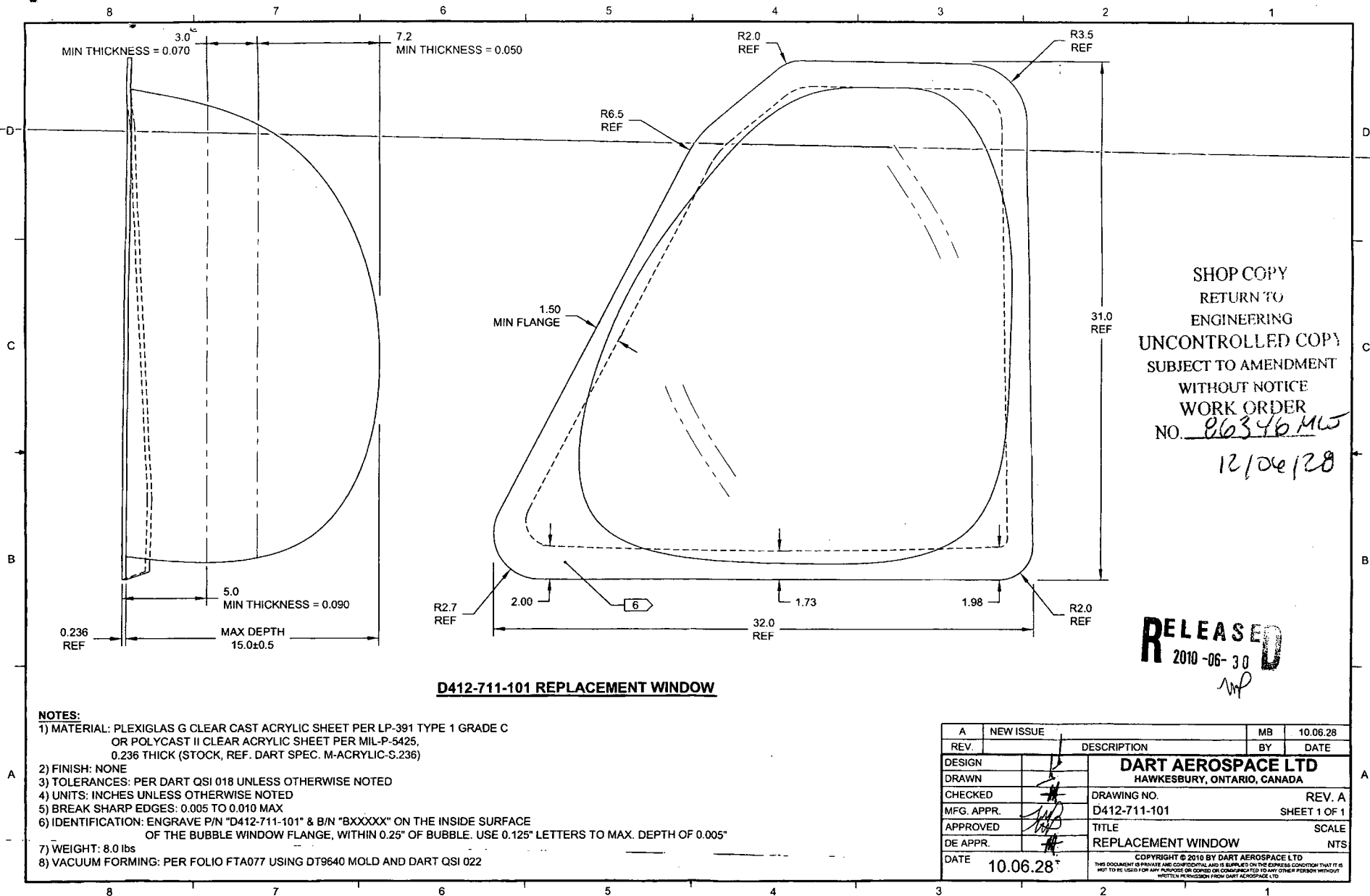
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Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: MLV

Date: 12/06/28 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-711-101	A								
100		0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefiles and create labels for PPP D412-711-101 Change 002								
110		0.00							
110	HAND FINISHING THERMOFORMING								
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Set up Machine as per folio FTA 077 and D711W program using mould DT9640								
120		0.00							
120	HAND FINISHING THERMOFORMING								
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Cut Blanks to 37.5" by 43"								

x5

DL
17/07/03

x5

DL
17/07/03